

# Work Order ID 52842

October 15, 2009 12:36:06 PM



Page 1

Item ID: D3805-047  
 Revision ID: A  
 Item Name: Wearplate Assembly Aft, High Gear  
 Start Date: 15/10/2009 Start Qty: 5.00  
 Required Date: 27/10/2009 Req'd Qty: 5.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: RL Date: 09-10-15 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3805	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

1- on D3806-7, fill cut outs with hardcoat welding rod as per dwg D3805  
 2059 B Hardcoat Welding Rod  
 BATCH#: M110763

2-weld D3806-7 to wearplate by positioning holes together as per dwg D3805  
 304 S.S. Welding Rod  
 BATCH#: M108160

Plate Batch# 52839 x 5

BAR Batch# 52854 x 5

RL 9-10-29 (X5)

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Quality Control

Memo

0.00

PD 09.10.29 (5)

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Page 2

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 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	2) 80916129			(X5)	/		
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M109091 Memo START 1:50 OVEN T. 320° FINISH 2:20	0.00 0.00	BK 09-10-29			(5)			
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	2) 80916129			(X5)	/		

**Work Order ID 52842**

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Page 3

Item ID: D3805-047  
Revision ID: A  
Item Name: Wearplate Assembly Aft, High Gear

Accept

Setup Start

Stop

Start Date: 15/10/2009 Start Qty: 5.00  
Required Date: 27/10/2009 Req'd Qty: 5.00

Cust Item ID:




Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Small Fab	<b>Memo</b> 1- Bond D3807-7 gasket to inner surface of wearplate using Scotch-grip adhesive. A/R Scotch-grip batch : <u>B52838</u>	0.00 0.00							<u>09/11/03</u> (5)
160  QC	QC5- Inspect part completeness to step on W/O	0.00							(15) \$
170  Packaging	Identify as per dwg & Stock Location: <u>FP20</u>	0.00							<u>MS 09/11/04</u> <u>XS</u>
Packaging	<b>Memo</b>	0.00							

**Work Order ID 52842**

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Page 4

Item ID: D3805-047  
Revision ID: A  
Item Name: Wearplate Assembly Aft, High Gear

Accept



Setup Start



Stop



Start Date: 15/10/2009 Start Qty: 5.00  
Required Date: 27/10/2009 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/11/05 *[Signature]*  
MF 09-11-05

# Picklist Print

November 02, 2009 11:52:08 AM

Page 1

Work Order ID: 52842

Parent Item: D3805-047RevA

Parent Item Name: Wearplate Assembly Aft, High Gear


Comments:

Start Date: 10/15/2009

Required Date: 10/27/2009

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3805-7RevA  Plate		Manufactured	No				Each	12.0000	5.0000		EL 7-11-4	

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

WA

12

52839

12

D3806-7RevA

Manufactured No



Bar

Each

18.0000

5.0000



EL 9-11-4

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

18

46787

4

52854

14

D3807-7RevA

Manufactured No



Gasket

Each

16.0000

5.0000



9/30/11/03

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

16

52838

16

5

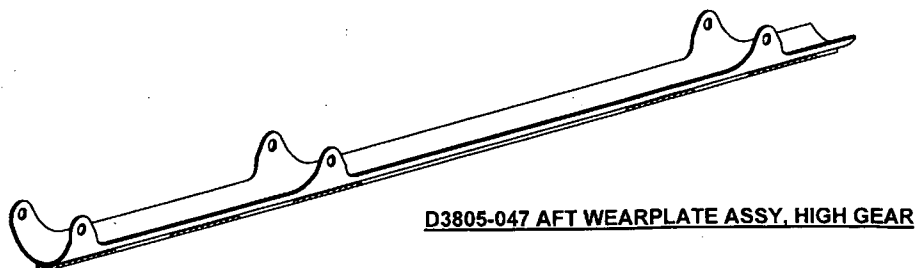
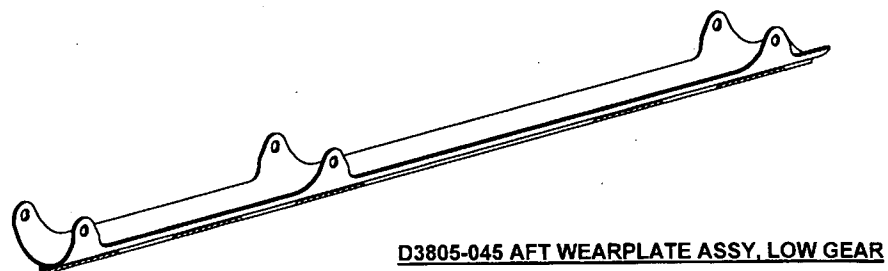
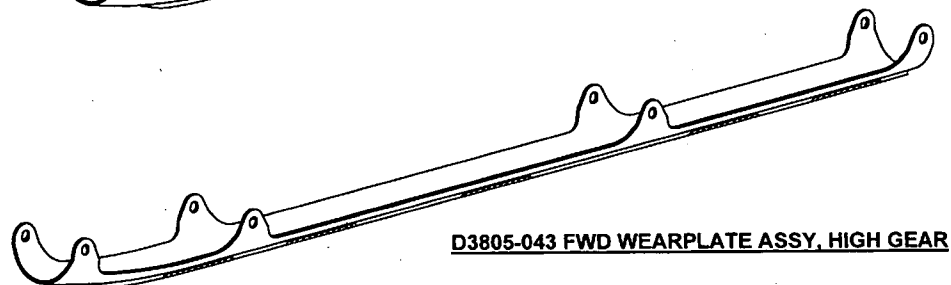
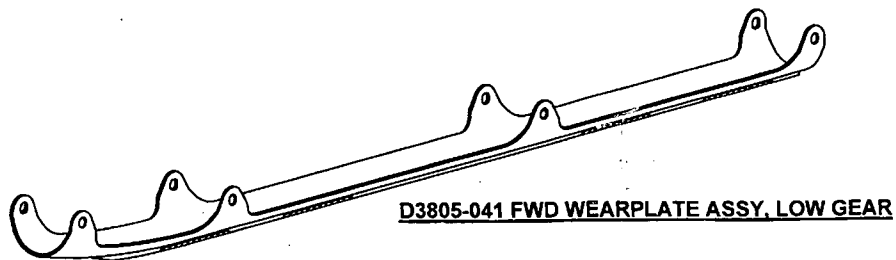
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



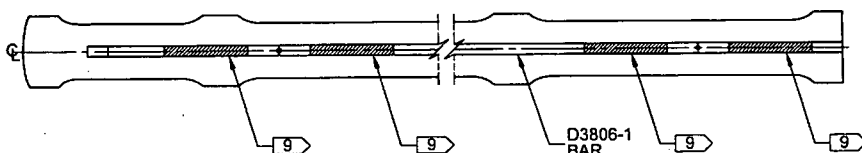
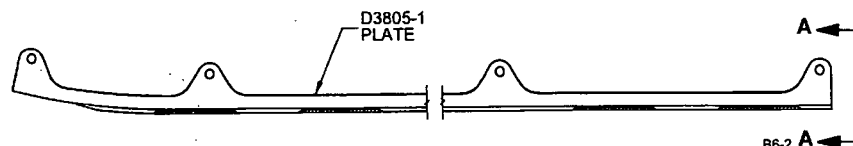
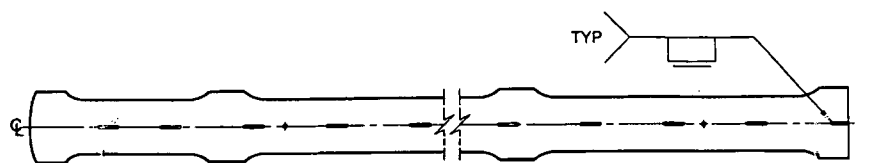
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1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

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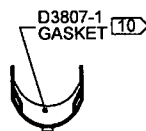
09-10-15

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09-03-03  
Per ECN 09-538

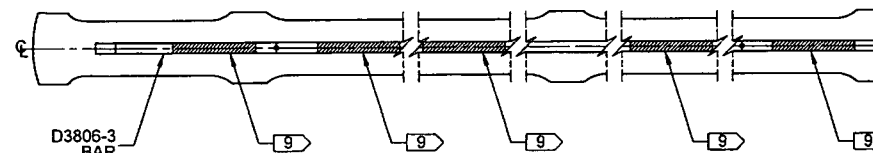
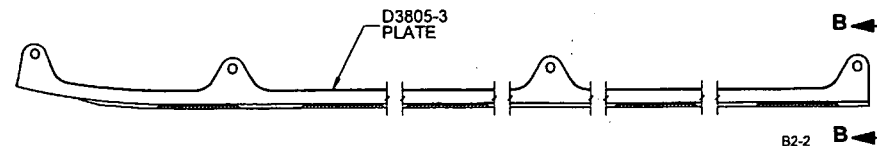
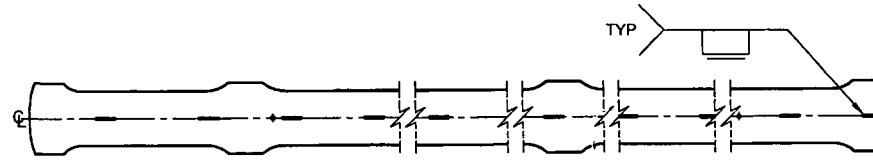
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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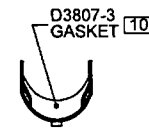
**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**



**VIEW A-A** C5-2



**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



**VIEW B-B** C1-2

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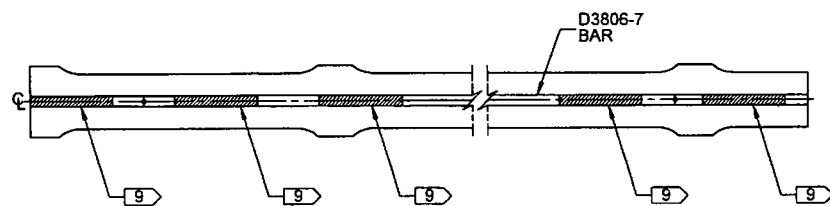
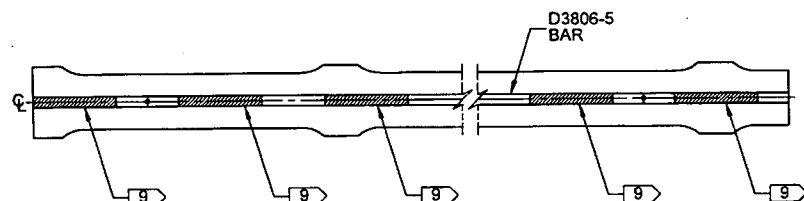
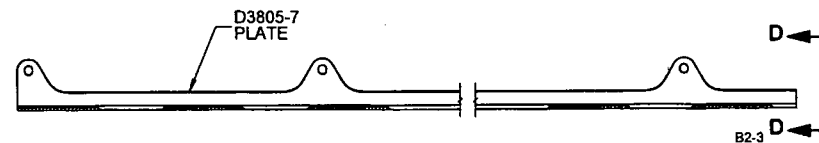
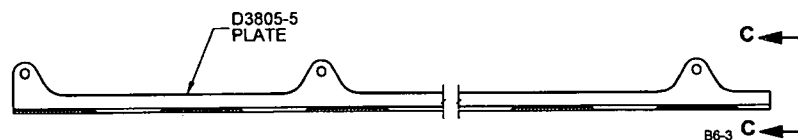
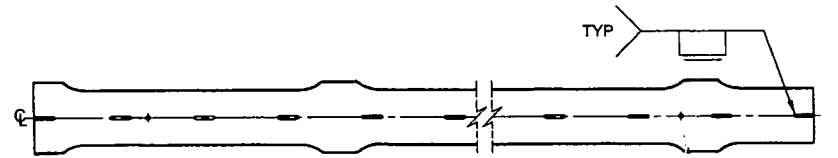
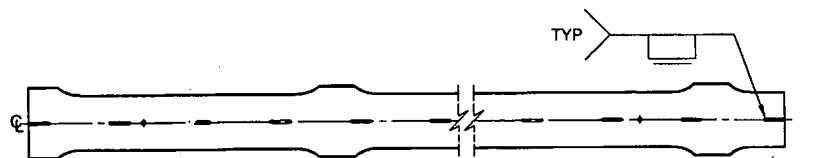
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09.03.03

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

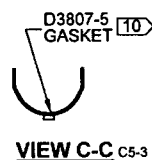
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MFG. APPR.	JS	D3805	SHEET 2 OF 8
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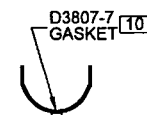


**D3805-045 AFT WEARPLATE ASSY.**

**D3805-047 AFT WEARPLATE ASSY.**



**VIEW C-C C5-3**



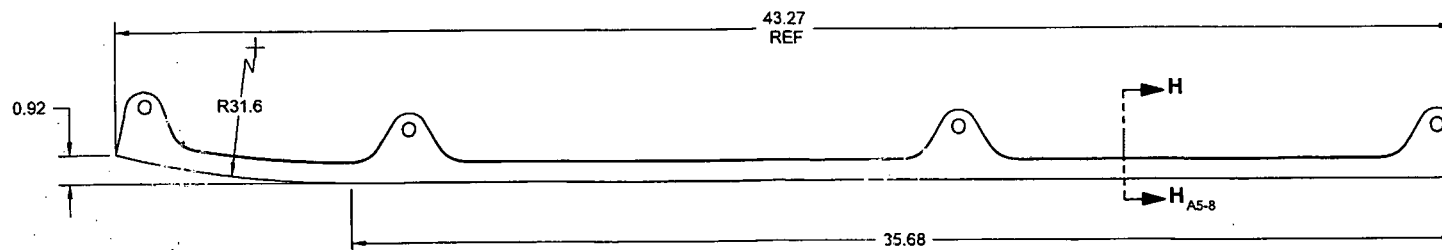
**VIEW D-D C1-3**

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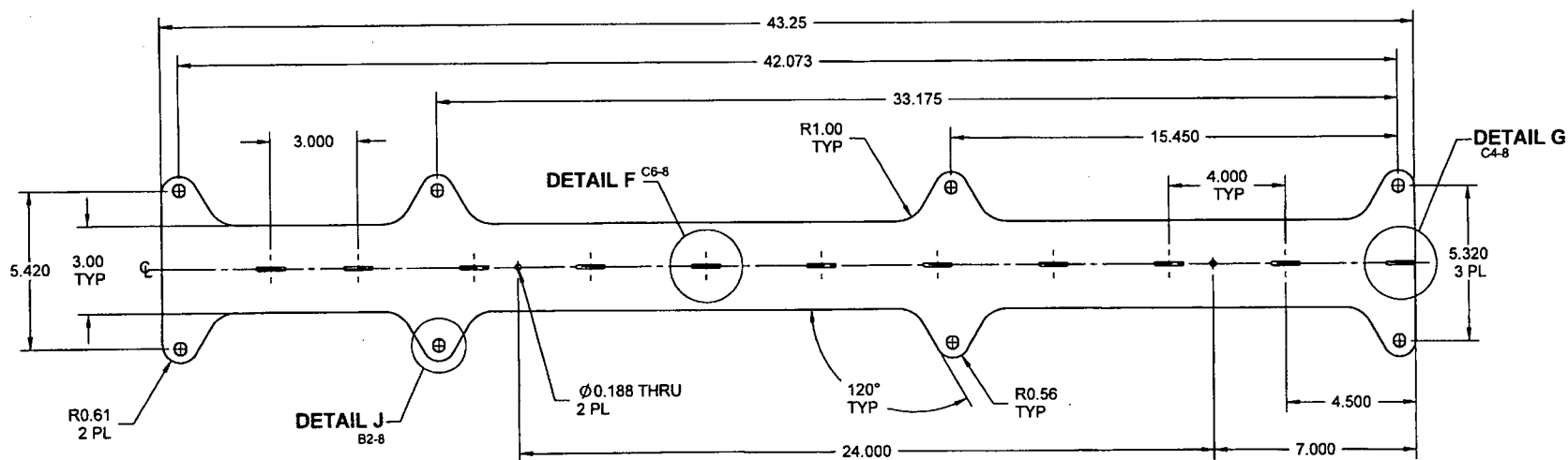
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09.03.07

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3805-045 = 3.93 lbs; D3805-047 = 4.21 lbs
  - 8) WELDING: PER QSI 004
  - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
  - 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

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DE APPR.	10	WEARPLATE ASSY	NT
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**D3805-1 PLATE**  
(MAKE FROM D3805-1F)



**D3805-1F PLATE**

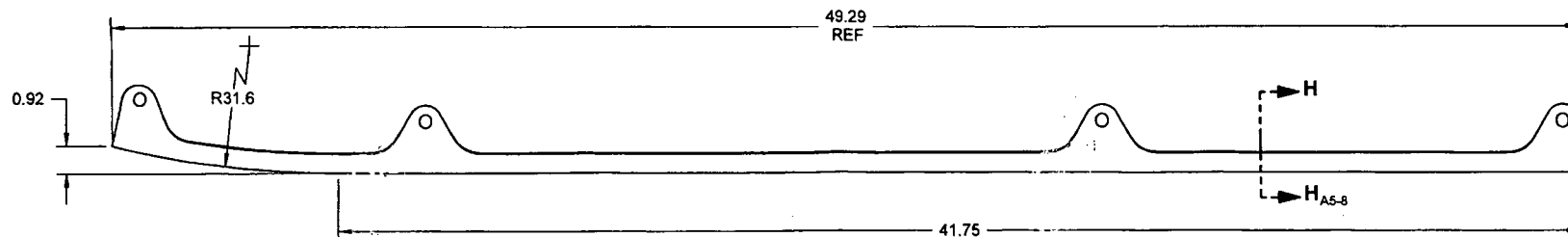
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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 2.11 lbs

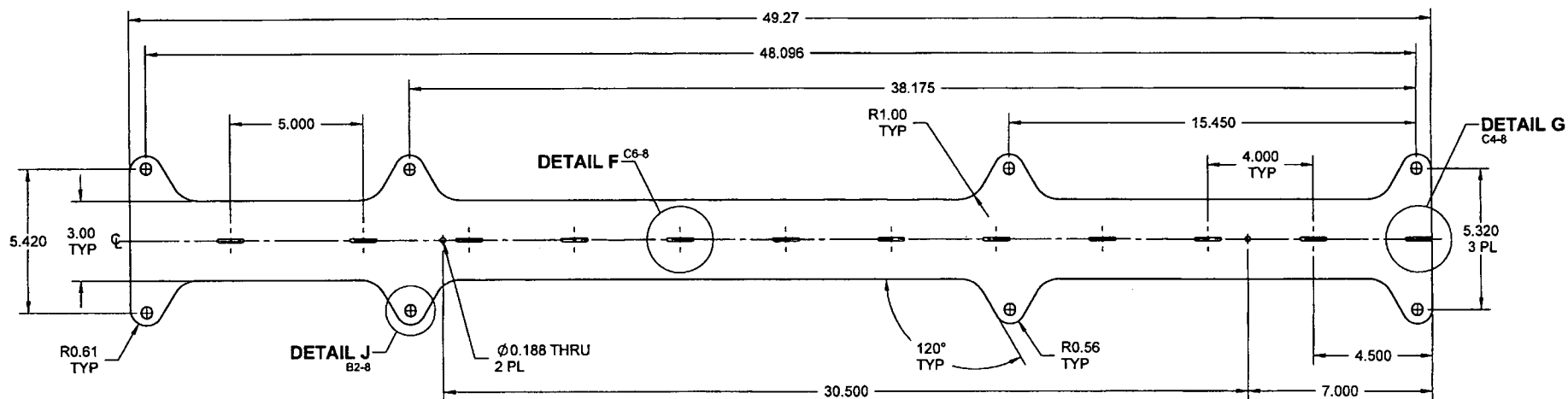
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MFG. APPR.	140	<b>D3805</b>	SHEET 4 OF 8
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8 7 6 5 4 3 2 1



**D3805-3 PLATE**  
(MAKE FROM D3805-3F)



**D3805-3F PLATE**

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09.03.07

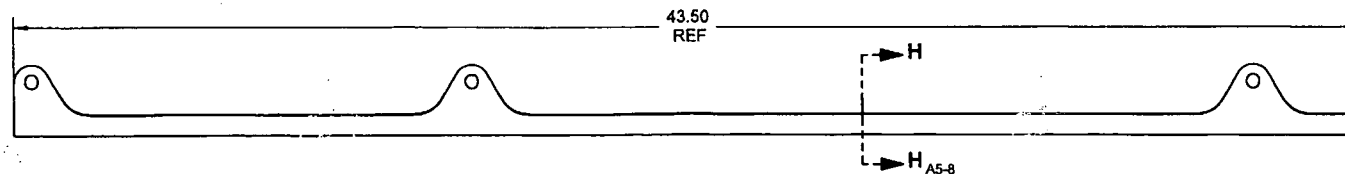
**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
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REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.37 lbs

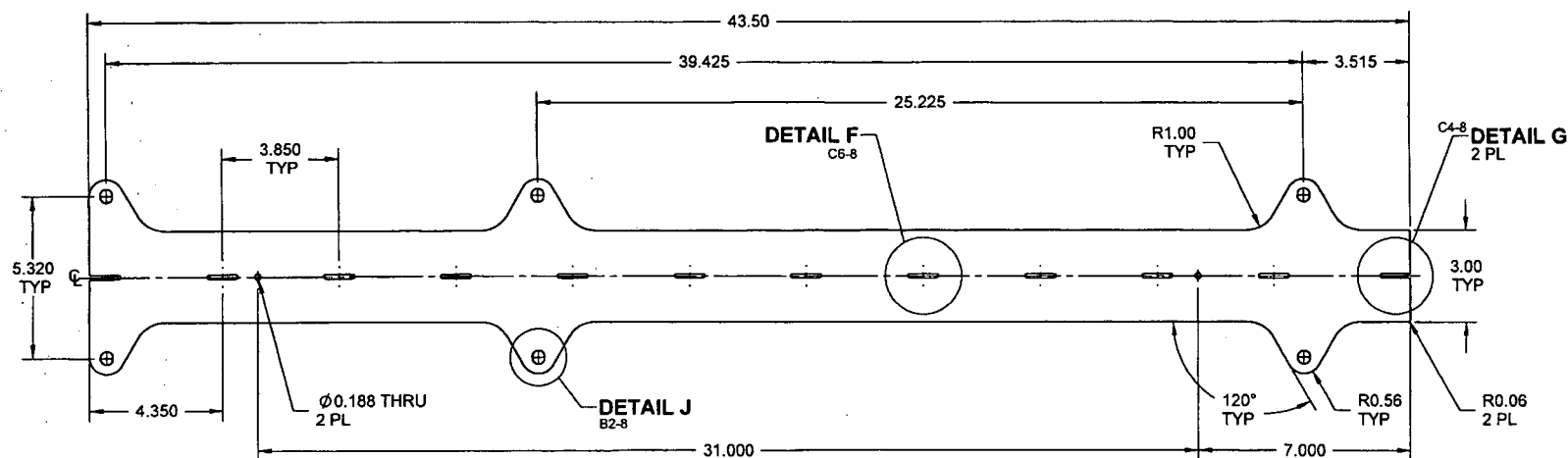
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CHECKED	AS	DRAWING NO. <b>D3805</b>	REV. A
MFG. APPR.	AS	SHEET 5 OF 8	
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	<b>WEARPLATE ASSY</b>	NTS
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8 7 6 5 4 3 2 1



**D3805-5 PLATE**  
(MAKE FROM D3805-5F)



**D3805-5F PLATE**

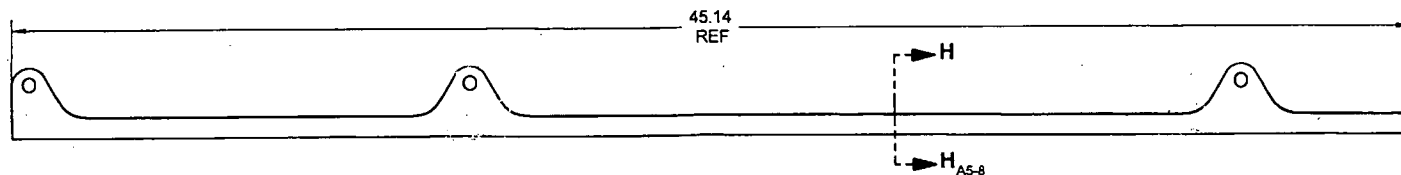
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04-03-03

**NOTES:**

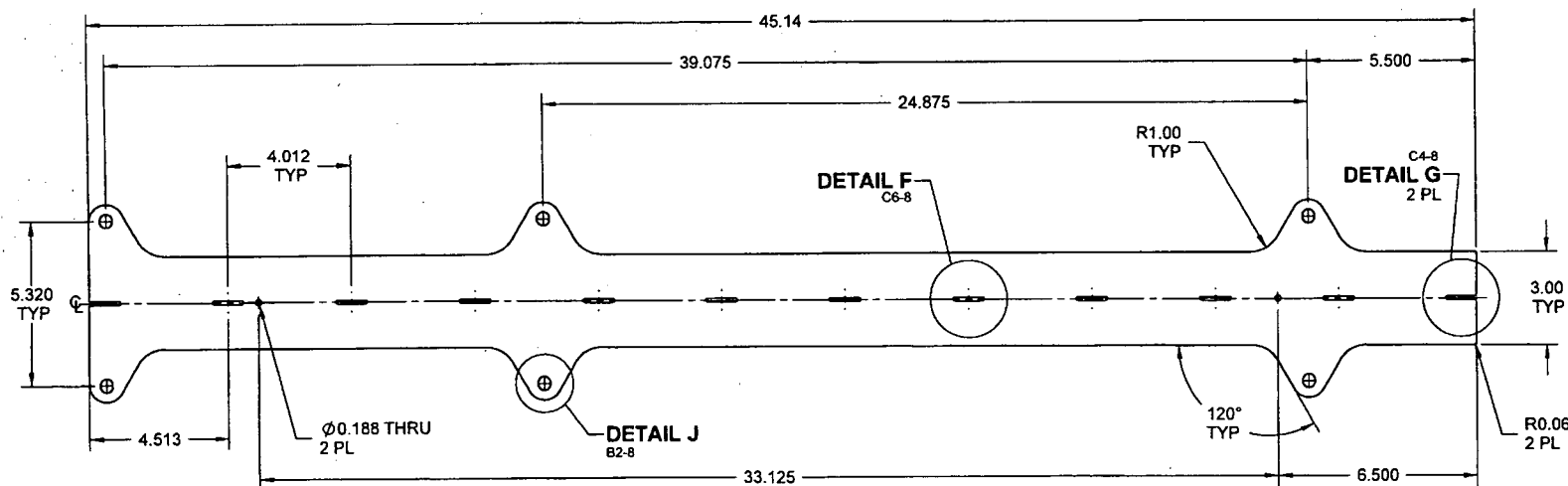
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

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NO. 52842

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CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	JS	D3805	SHEET 6 OF 8
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**D3805-7 PLATE**  
(MAKE FROM D3805-7F)



**D3805-7F PLATE**

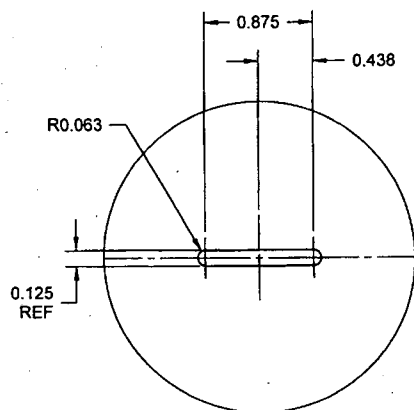
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04.03.07

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.13 lbs

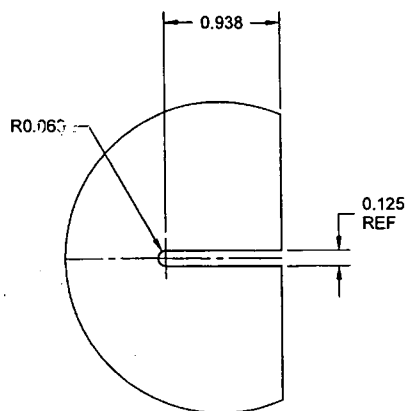
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MFG. APPR.	10	<b>D3805</b>	SHEET 7 OF 8
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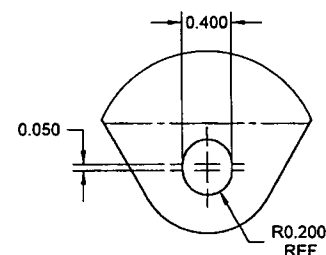
**DETAIL F**  
SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-5  
C4-6  
C4-7



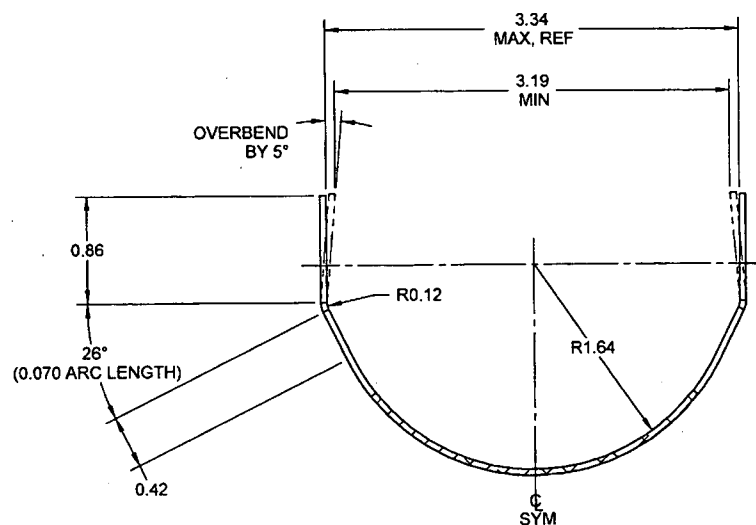
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

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